

9/25/19

[Dart Hawkesbury] Job Sheet - Guerin, Kimberley

5217704



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2244-116
Job Sheet 201109



Part No: D2244-116

Job Qty: 30 pcs

Part Name: Step Extrusion



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/25/19

Job Tracking No:

Due Date: 9/27/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV D1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Workcenter / Supplier Lead Time	Sign-off
100	Purchasing	30 pcs	9/27/19	9/27/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	30 pcs	9/27/19	9/27/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Container No: S217704



Part: D2244-116

Job No: 201109

Serial No/Batch: S217704

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/27/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 9/25/19 10:37 AM Dart.Guen.

120 QC 6	30 pcs	9/27/19	0.00 0.00	Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	61
				QC 6 - 40	9-89
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	30 pcs	9/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	3/8
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
140 QC 21 - SA	30 pcs	9/27/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-89 OCT 0 2 201
				QC 21 - SA - 53	

Part Op 100 - (Purchasing) Issue P/O: _____ a) Extrude as per Dwg D2244 b) Material: 6061-T6 (QQ-A-200/8) c) Descriptions: Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 116" long g) Caradon Indalex Tool # MH-18865 h) Material cert's is required ***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE***
110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure certification are attached
120 - (QC6- All purchased or subcontracted products) Check Pull test per Dwg D2244 for compliance page attached.

Check hardness with Webster tester
130 - Packaging3 (Identify as per dwg & Stock Location: _____) LOCATION : WA003
140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2244-116P	Step Extrusion	30 pcs (1 ea)	100-Purchasing	SA17045
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2244-116P	30	0	0
Part Specifications				
Specifications could not be found.				

Plex 9/25/19 10:37 AM Dart.Guerin.Kimberley



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB043556



Supplier: SAP001-VC Hydro c/o M91634, P.O. Box 11634 Succursale Centre Ville Montreal QC H3C 5Y9 Canada Phone: 877-922-7272 Fax: 800 563 8310	PO No: POHB043556 PO Date: 5/28/19 Due Date: 6/21/19 Purchase Order Revision: Revision Date: Ship-To Contact: Guerin, Kimberley Phone: 613-632-5200 Ext: 298 kguerin@dartaero.com
Ship To: 1270 Aberdeen Street Hawkesbury ON K6A 1K7 Canada Phone: 613-632-5200	Via: Ground Pymt Terms: Net 30 Freight Terms: Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195425	D2244-116P			Step Extrusion ***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** ***MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE***	Received		6/21/19	60 pcs	60 pcs	0 pcs	\$44.47674/pcs	\$0.00



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K6A 1K7
Canada

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PURCHASE ORDER
POHB043556



Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	201109	D2244-116P			Step Extrusion ***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** ***MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE***	Firmed	-	9/26/19	30 pcs	0 pcs	30 pcs	\$44.47674/pcs	\$1,334.30

Grand Total: \$1,334.30

Order Notes

- Procurement Quality Clauses
- A005 RIGHT OF ENTRY
 - A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
 - A012 CHEMICAL AND PHYSICAL TEST REPORTS
 - A016 PERSONNEL QUALIFICATION
 - A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
 - A026 CERTIFICATION OF MATERIAL CONFORMANCE
 - A041 QUALITY MANAGEMENT SYSTEM
 - A042 DART NOTIFICATION BY SUPPLIER
 - A043 RETENTION OF QUALITY DOCUMENT
 - A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
 - A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/25/19 10:40 AM Dart.Guerin.Kimberley



Hydro Extrusion Canada, Inc
325, rue Avro
Pointe-Claire Québec H9R 5W3
Téléphone: (514) 697-5120
Télécopieur: (514) 694-8310

Packing Slip / 0173660
Détail de Livraison
Order no/
Commande 9051732 1

Ship to/Expéditeur DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7		Sold to/Vendu à DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7		Special Instr / Instr. Spéciales					
Cust No/No du Client 201355	Cust No/No-PO du Client HB043556	PPD/PAYÉ X	Ord Dte/Dte Comm 19/05/28	Our Ord Dte/ Notre Dte la Comm... 19/08/29	Hydro H.S.T #: R857314058				
PST/TPV *6122-5207		Date Required/ Date Requise		Shipped Via/ Expédié Par OTTAWA 20 SEPT					
Item No	Ordered Weight Pcs/ Commande Poids Pcs	Hydro Die no/ Matrice d'Sapa	Customer Description/ Description de Client	Alloy & Temper/ Alliage et Trempage	Length Longueur	Backorder Wgt Pcs Arrière Poids Pcs	This Shipment Bdls Pcs Wght Com Expédiée Ballots Pcs Poids		
1	500 86		DUE = 2019/07/04 STEP EXTRUSION MH 18865 D2244-116P 6061 T6 2946MM BUNDLE = 1425952 We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures				1	30	167 KGS

Aluminum Extrusions - Anodizing - Fabrication - Painting
Profils D'Aluminum - Anodisation - Fabrication - Peinture

The above items were received in good order.
Les articles ci-dessus ont été reçus en bon ordre.

By/Par.....



Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer: **DART AEROSPACE LTD**
Adresse / Address: **1270 ABERDEEN STREET**
HAWKESBURY, ONT K6A1K7

commande Hydro / Hydro order #: **9051732**

bon de commande / Purchase order #: **HB043556**

de matrice / Die #: **MH 18865**

Alliage & trempage / Alloy & temper #: **6061 T6**

Contrôle / Control #: **36395-6**

Coulée / Cast #: **75743**

Description #: **STEP EXTRUSION**

Customer Part #: **D2244-116P**

Conductivité / Conductivity : **N/A**

Propriétés mécaniques Mechanical Properties	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress (ksi)	38.00	42.00
Contrainte élastique Yield stress (ksi)	35.00	36.40
% élongation dans 2" % elongation in 2"	8	11.00
Dureté Rockwell E (hre) Rockwell E Hardness (hre)	N/A	N/A

Composition chimique Réelle / Real chemical composition :

Alliage	Cast no	Si	Pb	Cu	Mn	Mg	Cr	Zn	Ti
6061	75743	0,577	0,224	0,206	0,058	0,794	0,063	0,017	0,014

Certificat

Hydro Extrusion Canada, Inc. certifie par la présente que le métal expédié sous ce rapport a été testé conformément à la norme ASTM B221-14 identifié et / ou spécifications ASME SB 221-17 et les résultats de l'analyse chimique et les propriétés mécaniques des tests sont dans les plages d'acceptabilité des spécifications. La garantie du produit est régie par Extrusion Amérique du Nord. Les conditions standard des ventes sont affichées sur la page web www.hydroextrusions.com/termsconditions.

Certification

Hydro Extrusion Canada, Inc. hereby certifies that the metal shipped under this report has been tested in accordance with the identified ASTM B221-14 and/or ASME SB 221-17 specifications and the results of the chemical analysis and mechanical properties tests are within the acceptable ranges of these specifications. Any product warranty is governed by the Extrusion North America Standard Terms and Conditions of Sale posted at www.hydroextrusions.com/termsconditions.

Sincèrement vôtre,
Yours truly,

Date : **17.09.2019**

Baharak Sarrafan
Directrice Qualité
Quality Manager

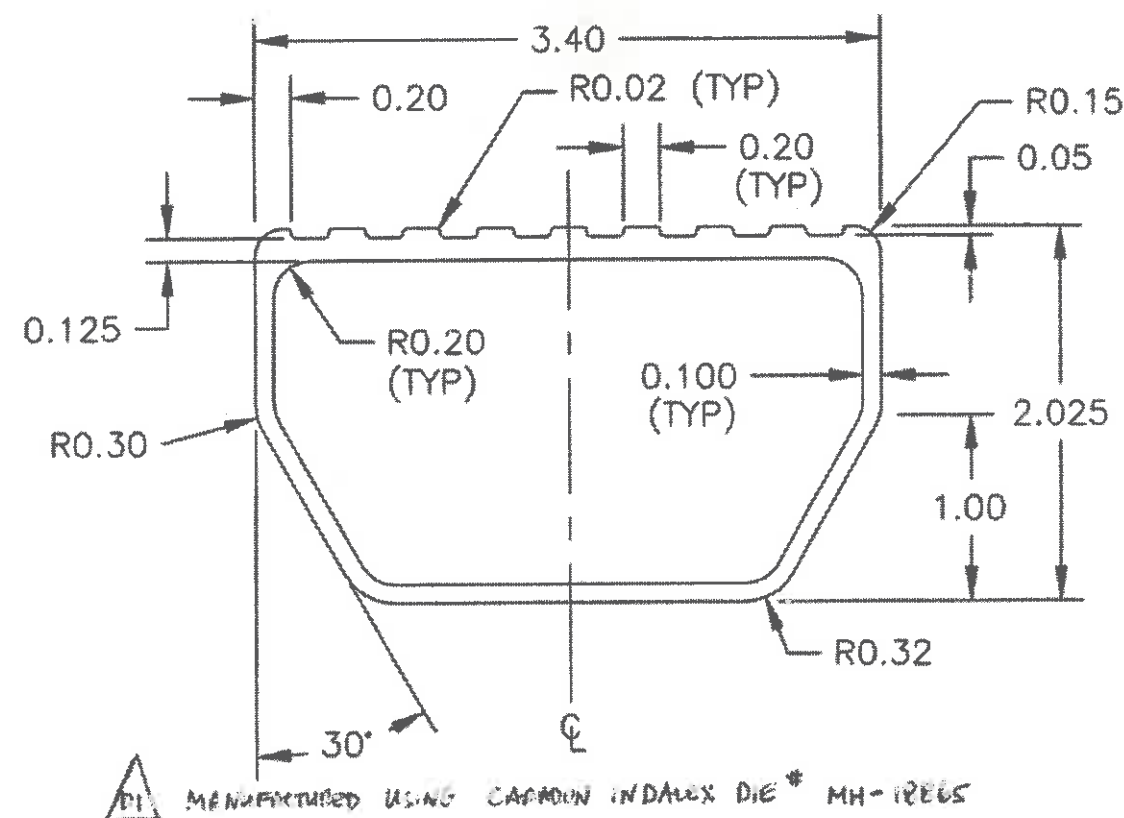
Hydro
Extrusion North America
325 Avro
Pointe-Claire, QC H9R 5W3
Canada

DART



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2244	REV. D SHEET 1 OF 1
DATE 98.11.18	TITLE STEP EXTRUSION		SCALE 1:1
A	94.07.05	NEW ISSUE	
B	94.07.11	REDESIGNED	
C	94.08.08	REDESIGNED	
D	98.11.18	REMOVED 6005A MATERIAL INCORPORATED DEO 9081	
D1	01.04.17	ADDED DIE # <i>4 CP</i>	

RELEASED
1/2/25 AL



PART NUMBER D2244-XX.X
XX.X IS CUT LENGTH IN INCHES

MATERIAL: 6061-T6 (QQ-A-200/8)

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2144-116

DATE: 19/09/27

PO / BATCH NO.: POHB043556

MATERIAL CERT REC'D: Ks

THICKNESS ORDERED: 2.025"

QUANTITY RECEIVED: 30x

THICKNESS RECEIVED: 2.025"

QUANTITY INSPECTED: 30x

SHEET SIZE ORDERED: —

QUANTITY REJECTED: —

SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	D2144-116P
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	POHB043556
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	WEBSTER

testers located in the Quality Office

QC 18 INSPECTION

ENGINEERING SIGNOFF (if required)

INSPECTED BY: 9-89

SIGNED OFF BY: —

DATE: SEP 27 2019

DATE: —

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in